

50 CAL 1-PIECE BARREL
Machining Specification
January 14, 2011

- WSTF will supply five rough turned forgings 4.125" diameter x 165" Long per ASTM A 688 – 96 (AISI 4340) in the normalized, quenched, and tempered condition (Class N) to 140,000 psi minimum yield strength.
- Vendor to quote all machining per the following drawing.
 - NASA Drawing No. 254-15570 Rev. N/A.
- Surface finish of forging ~250 RMS
- Drill bits supplied by WSTF.
- Drawings required for proper thread dimensions of mating parts will be supplied by WSTF upon request.
- Vendor will notify WSTF within 48 hours of receipt of parts and material from WSTF if any said items arrive in damaged condition.
- If materials require replacement due to vendor negligence, identical materials will be re-supplied at vendor's expense.
- Vendor to quote both price and best delivery time. WSTF will notify vendor a minimum of 1 week prior to shipment of materials from WSTF.
- Vendor to coat 1-piece barrels with a corrosion inhibitor prior to shipment.
- Vendor will package (crate & wrap) finished parts in a manner which will minimize damage, bending, corrosion, and exposure to weather and road conditions such as rain, dust and rocks. Thread protectors will be used to prevent damage due to handling.
- WSTF may elect to reverify chemical composition and hardness upon parts receipt to verify conformance to specification. Payment is subject to final inspection, which shall be performed within 2-weeks of date of receipt.
- Deviations to specification and/or drawing shall require written approval by WSTF.